

- 1/6 -

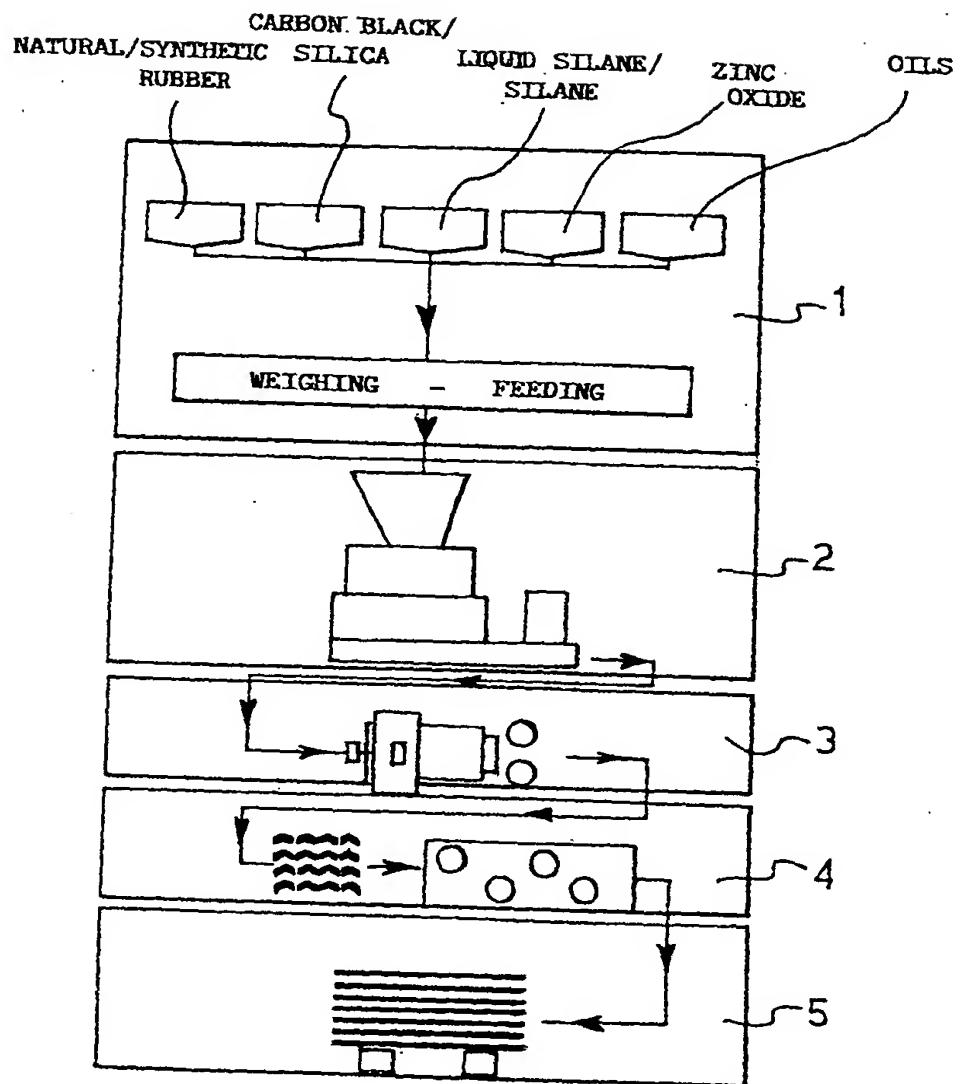


FIG. 1

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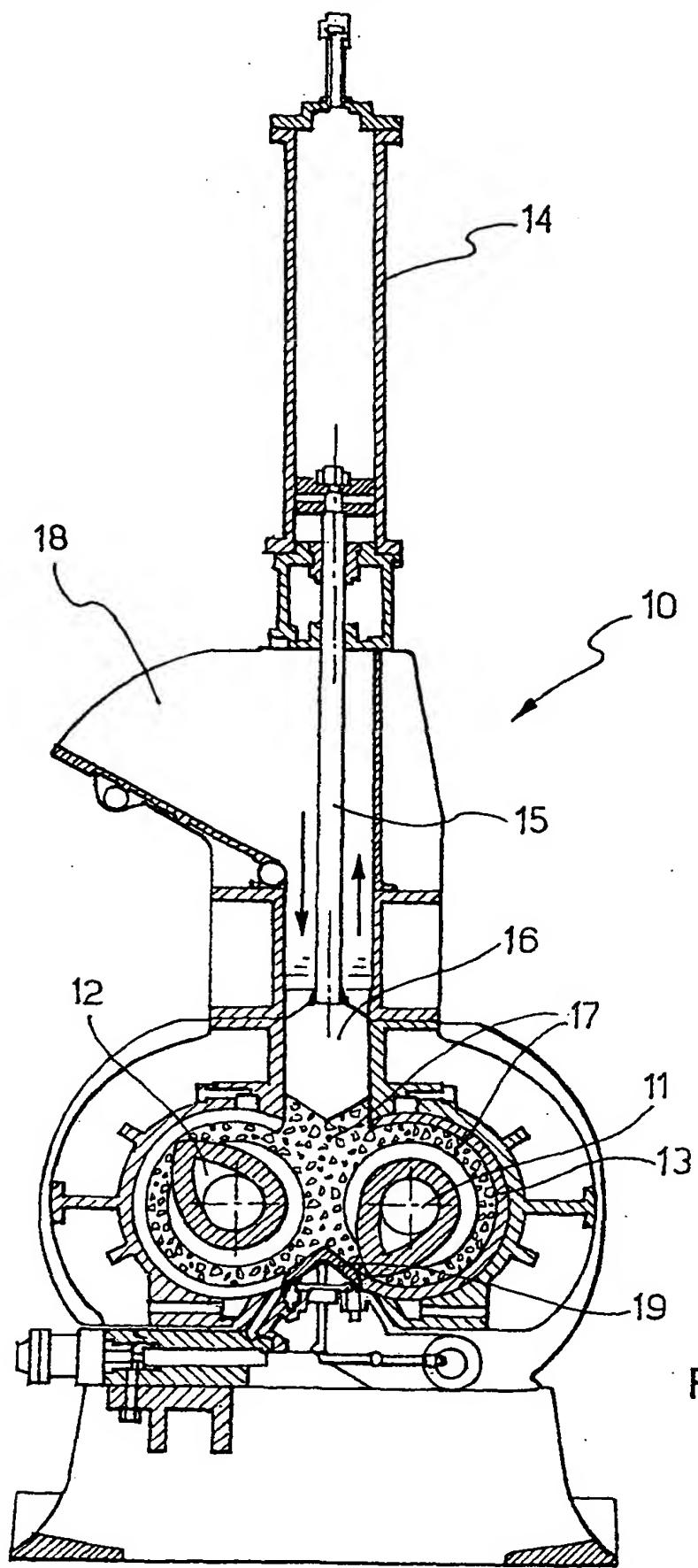


FIG. 2

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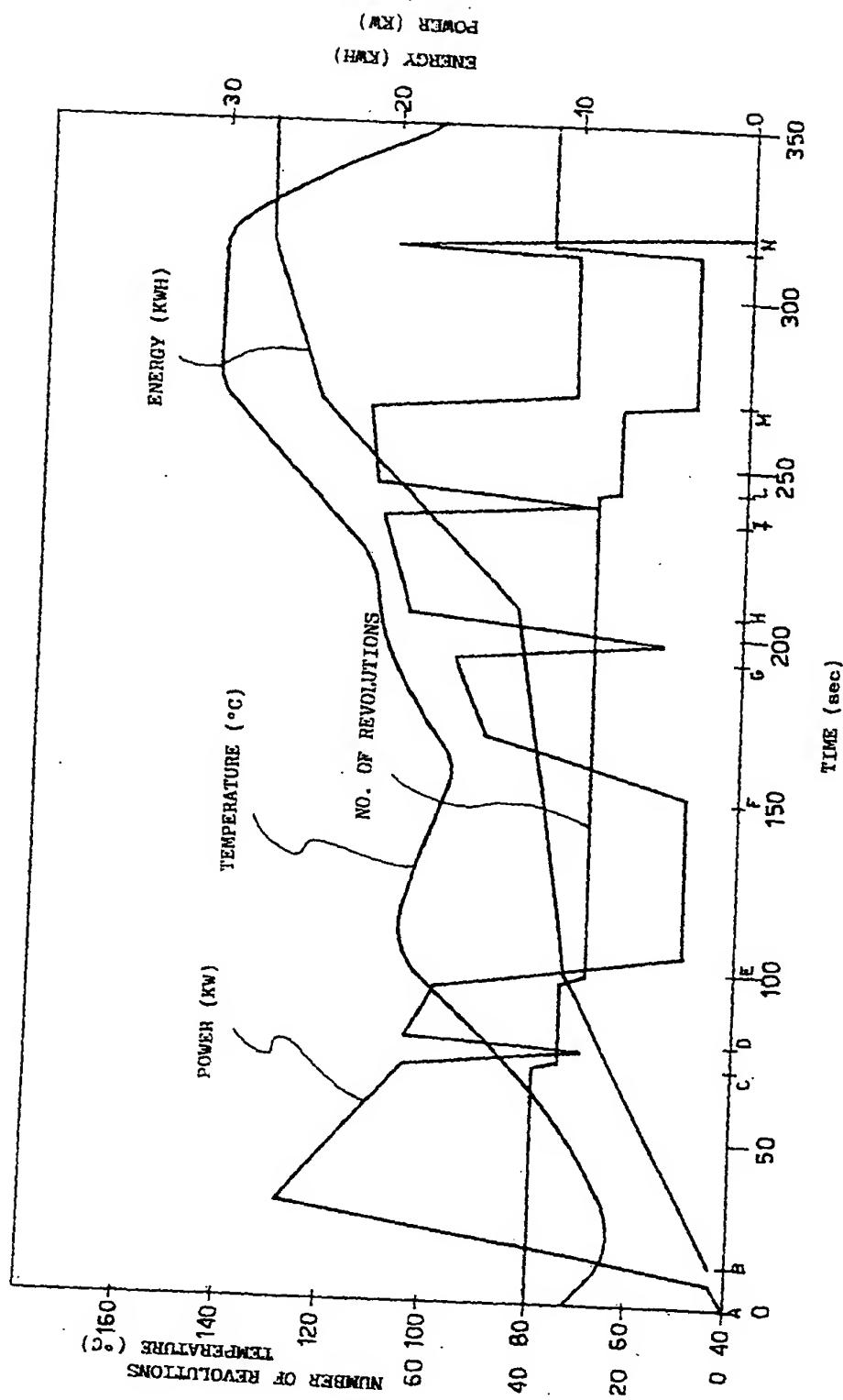


FIG. 3

PROCESS PARAMETERS	EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES		NON-COMPLIANT CYCLES		BASIS: TOTAL SCORE			
	MIXTURE		MIXTURE					
	STEP NO.	SET. VALUE	TOL. -	TOL. +	WEIGHT	STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE
STEP TIME (sec)	H - I	30	0	6	5	H - I	40 SEC	NO
INITIAL TEMPERATURE (°C)	I	120	0	5	5	I	120 °C	YES
INITIAL ENERGY (KWH)	I	17.5	1.5	1.5	5	I	19.7 KWH	NO
STEP TIME (sec)	L - M	25	5	6	7	L - M	42 SEC	NO
INITIAL TEMPERATURE (°C)	M	145	0	0	0	M	145 °C	YES
INITIAL ENERGY (KWH)	M	24.5	2.4	2.4	8	M	27.7 KWH	NO
STEP TIME (sec)	N	315	45	125	10	N	470	NO
INITIAL TEMPERATURE (°C)	N	245	25	120	40	N	308	YES
PARTIAL CYCLE TIME (sec)	N	27.0	1.0	4.0	10	N	32.1	NO
TOTAL MIXING TIME (sec)	N	146	4	4	10	N	144	YES
TOTAL ENERGY (KWH)								100
INITIAL TEMPERATURE (°C)								45
								DEFECTIVE 2nd DEGREE

SUBSTITUTE SHEET (RULE 26)

Fig. 4

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REFERENCE CLASSIFICATION		
</= 6 min	:	NORMAL
> 6 min / 9 min	:	DEFECTIVE 2 nd DEGREE
> 9 min	:	REJECT

PROCESS PARAMETERS	DETECTED VALUE
MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER	11 min

► REJECT

FIG. 5

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